

Blue

Work Order ID 62619

October 5, 2010 11:46:51 AM

Page 1

Item ID: D206-642-441

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Setup Start



Required Date: 10/22/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:



Date: 10-10-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2650	Rev F

100



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441

CHG002

N/A KJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Werk Order ID 62619

October 5, 2010 11:46:52 AM



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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

110



Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

BE 10/10/13

BE 10/10/13

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650
required.

A/R Aluminum Rod m111385 m115778 BE 10/10/13

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

required.

4-Grind weld flush to cap on top surface only.

BE 10/10/13

5-Cut aft end 138.60" from front of tube

7

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to
00.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

8

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling
Detail

BE 10/10/13

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

9

11-Deburr and Blow out all chips form inside the tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 62619

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Start Date: 10/05/10 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC: _____

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Skidtubes

Skidtubes

0.00

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cuttingStart Date: 10/10/21 Time: 11:30Finish Date: 10/10/25Time: 3:00 pmSikaflex-291 11/15/14 Sikaflex expiry date: 11/01/01

10-10-19

BB 10/10/0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 10/05/10 Start Qty: 1.00



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Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

10/10/25

70

160



Skidtubes

Skidtubes

0.00

1

Skidtubes

Memo

0.00

-

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod m11385

BE 10/10/26

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" ~~deep as per Dwg D2650~~ Deburr

DP

10-10-26

D

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170

Operation
Description

HandFinishing

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650

DP 10-10-26

180



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S10/10/27

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/10/27

QC

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

W/O:		WORK ORDER CHANGES					
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Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Pressure Wash per QSI005 4.3

0.00

7/10

10/05/29



Hand Finishing

Memo

0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

211



SprayPaint

Memo

0.00

Spray Painting

PRIME B 115967

PAINT DELFLEET BLUE B 115509

CLEAR DELFLEET B 115949

0.00

10/11/03 (1)

221



QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

10-11-04 (K)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

230



HandFinish

Hand Finishing

0.00

2) 10/11/08

1 9

HandFinishing

0.00

Memo
1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside
insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 10/11/08
Sikaflex expiry date: 10/11/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install
plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 10/11/08
Sikaflex expiry date: 10/11/08

6-Wing Walls as per Dwg D2650-7 and QSI 005 4.4
Batch: 10/11/08

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Revision ID:

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Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

MM 10 11 09 01

250



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPP 62619 10/11/09

260



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

October 5, 2010 11:46:40 AM

18

Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC

IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K

10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased		No		230	Each	1,214.000	60	60	60	10/11/08	

Insert

Location	Loc Qty	Loc Code
----------	---------	----------

PKG11	1165	
-------	------	--

114723	1165	
--------	------	--

ST282	10	
-------	----	--

110511	10	M1115911
--------	----	----------

ST381	39	
-------	----	--

114654	39	
--------	----	--

AN960JD10L NAS1149D0332J Purchased



Washer

AN960JD416 NAS1149D0463J Purchased



Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	24	
-------	----	--

113288	24	
--------	----	--

M1115622	V1
----------	----

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3



Purchased No

170

Each

446.0000

2

2



Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	446	
112314	4	
113539	44	
113973	398	(2)

CR3212-4-03



Purchased No

230

Each

1,888.000

2



Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	1888	
111359	5	
112314	2	
114436	448	
114450	71	
114859	1362	(2)

D2620



Manufactured No

110

Each

8.0000

1



Skidtube, 206 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	8	
61632	8	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2646



Manufactured No

110

Each

50.0000

1

1

Aft Cap

blue

X

Location	Loc Qty	Loc Code	
FP-4	45	B62610	X1
57332	45		
fp5	1		
61752	1		
FP6	4		
52663	4		

D2647



Manufactured No

140

Each

66.0000

1

1

Cap

Location	Loc Qty	Loc Code	
FP	66		
55352	66		

D2649



Manufactured No

170

Each

65.0000

23

23

Cross Bolt Spacer

Location	Loc Qty	Loc Code	
LG	65		
58545	2		
60652	4		
61496	59		

X

X

X

X

B62889 23 BE 10/10/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230

Each

622.0000

22

22



Plug

blue

Location

Loc Qty

Loc Code

FP 252 362 638

51530 152

61751 100

fpa 370

53349 235

57869 135

10/11/08

D2651-3

Manufactured No

230

Each

626.0000

22

22



O-Ring

Location

Loc Qty

Loc Code

FP 626

46114 130

61962 496

10/11/08

D2654-7

Manufactured No

62686

160

Each

0.0000

1

1



Web

D2680-041

Manufactured No

170

Each

29.0000

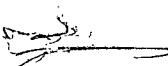
1

1



Nut Plate

Manufactured No



Location

Loc Qty

Loc Code

ST021 29

55366

29

1



DB 10/02/10
10-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 5
18

Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3535-15



Manufactured No

230

Each

6.0000

1

1



HL 1011108

Wearshoe

Location

FP18

Loc Qty

6

Loc Code

B62707

Y1

61241

6

D3535-23



Manufactured No

230

Each

19.0000

1

1



HL 1011109

Wearshoe

Location

FP

Loc Qty

7

Loc Code

Y1

61830

7

D3535-37



Manufactured No

230

Each

9.0000

1

1



HL 1011109

Wearshoe

Location

FP

Loc Qty

9

Loc Code

Y1

56101

9

D3536-15



Manufactured No

230

Each

10.0000

1

1



HL 1011109

Gasket

Location

Location

FP

Loc Qty

9

Loc Code

Y1

56055

1

60875

8

Location

FP11

Loc Qty

1

Loc Code

B62459

Y1

59238

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3536-23



Manufactured No

230

Each

8.0000

1

1



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	8	B63391
61237	8	

D3536-37



Manufactured No

230

Each

8.0000

1

1



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	8	
56102	8	

D3537-1



Manufactured No

230

Each

14.0000

6



Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	
55465	1	
FP17	13	
57713	3	B62666
60491	3	
61640	7	

D3537-3



Manufactured No

230

Each

8.0000

1

1

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP17	8	B61671
60866	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:46:43 AM

Page 7

Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

230

Each

1,585.000

2

2

Screw



Location	Loc Qty	Loc Code
ST291	1585	
110835	473	XZ
114718	112	
115108	1000	

MS27039-4-06

Purchased

No

230

Each

108.0000

1

1

Screw



Location	Loc Qty	Loc Code
ST292	108	
109061	14	X1
115460	94	

MS27039C1-08

Purchased

No

230

Each

1,077.000

60

60

SCREW



Location	Loc Qty	Loc Code
FP	276	X116022
115336	276	X60
ST293	801	
115589	800	
19185	1	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 8

October 5, 2010 11:46:43 AM

8

Work Order ID: 62619



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,239.000

60

60



10/11/08

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	5239	
113524	10	
113737	150	
115000	125	
115698	78	
115816	1276	
<u>115832</u>	3600	X60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				8					7					6					5					4					3					2					1					
D	QTY -1	QTY -3	QTY -5	QTY -7																																								

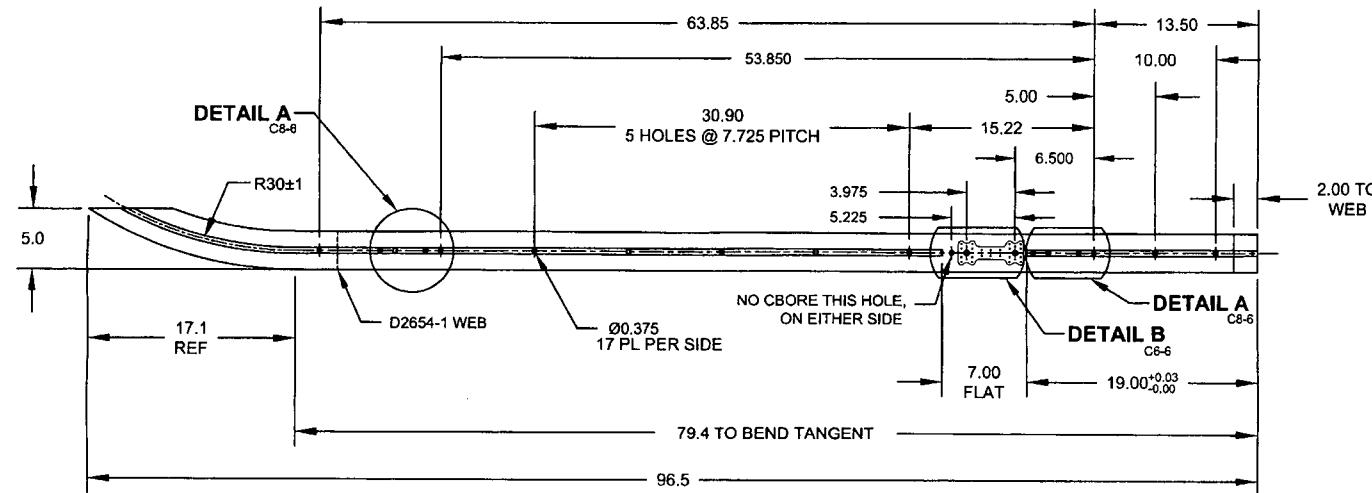
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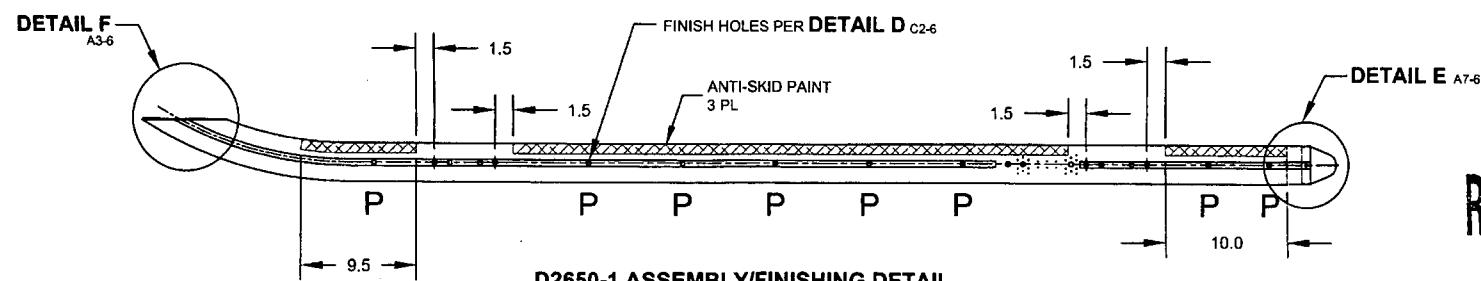
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL

11/10 62619



RELEASED
08-09-22 11:16

D2650-1 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.	PE	D2650	SHEET 2 OF 6	
APPROVED	MP	TITLE	SCALE	
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS	
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE USA, INC.		

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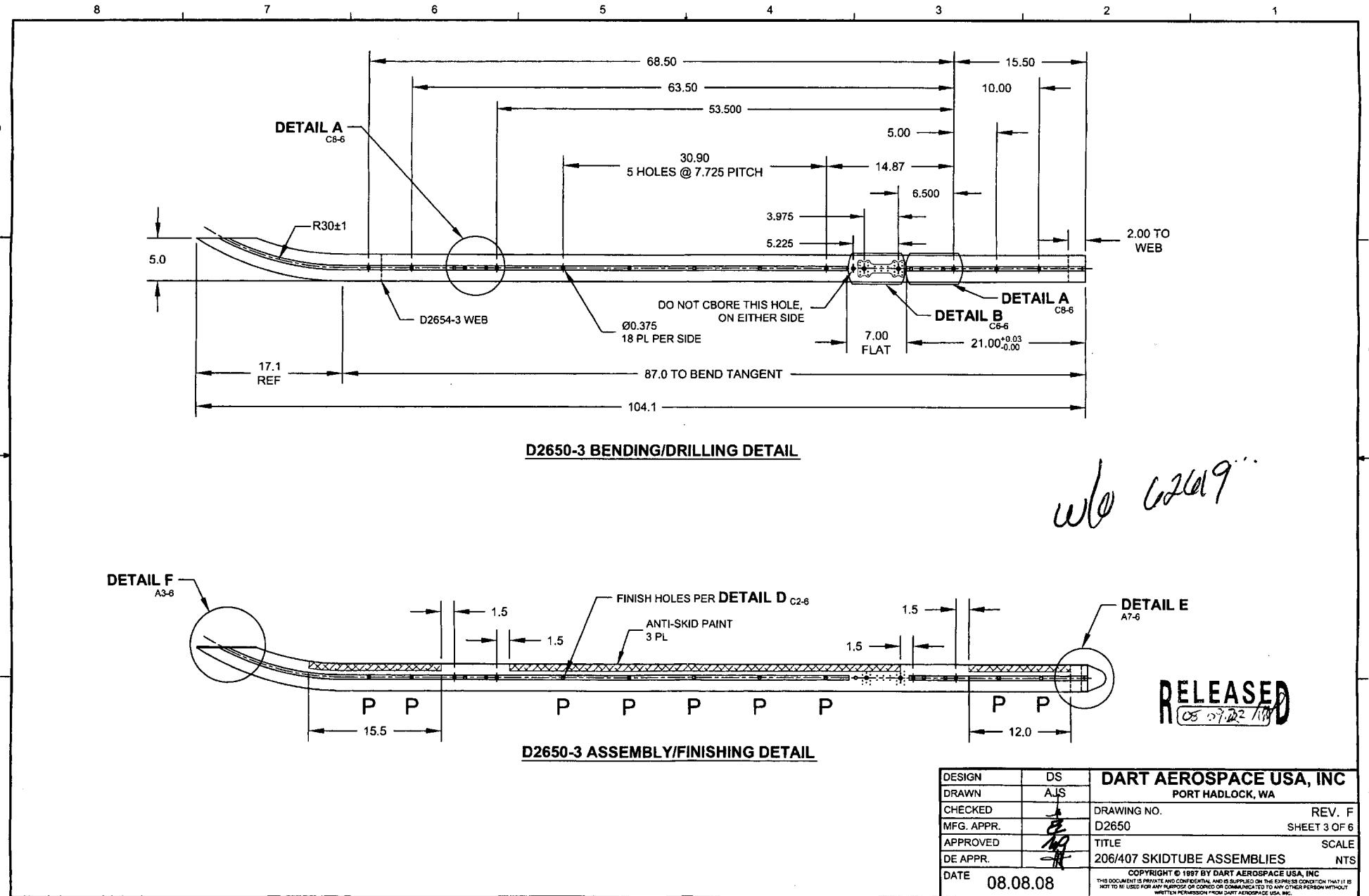
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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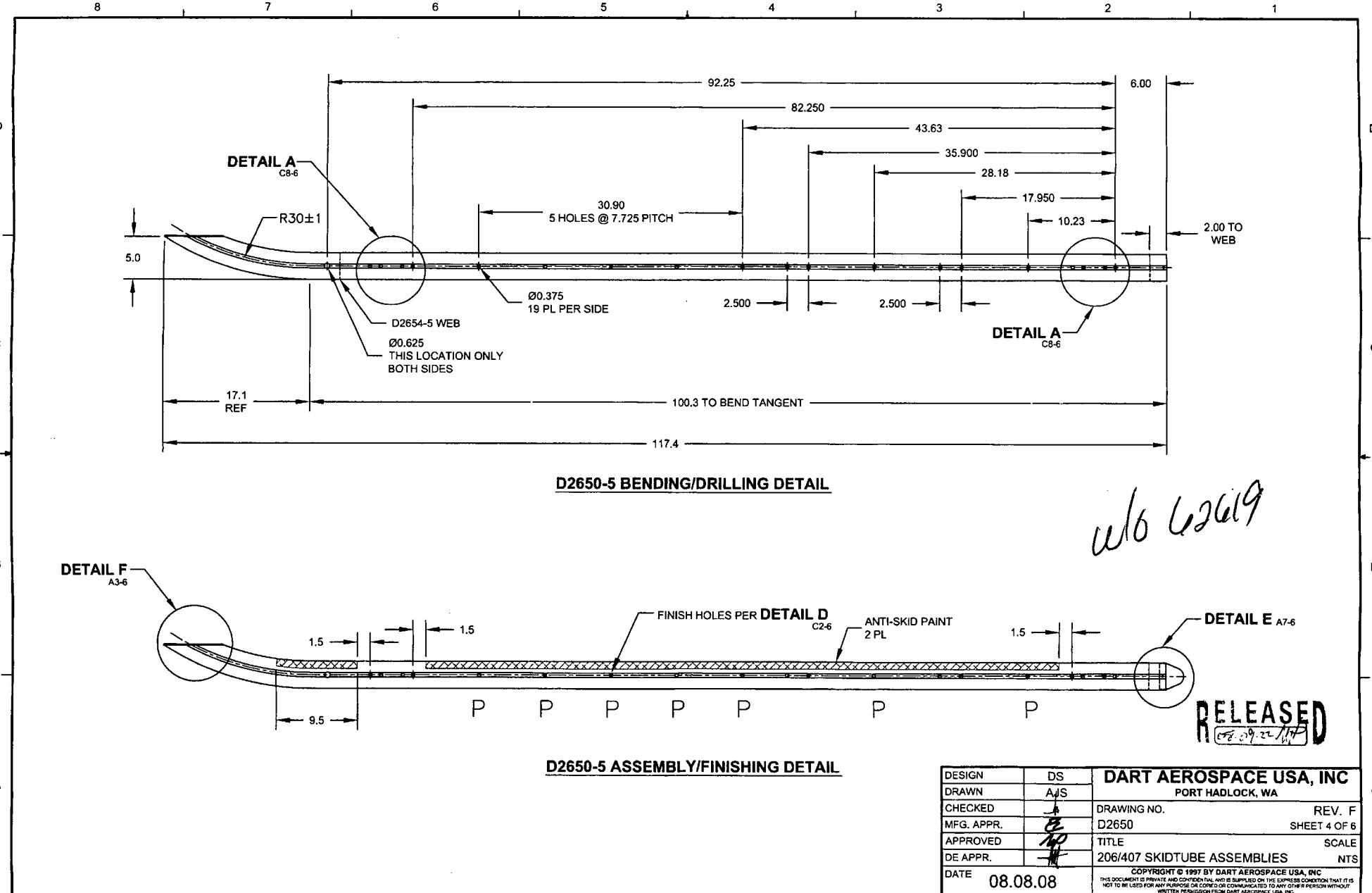
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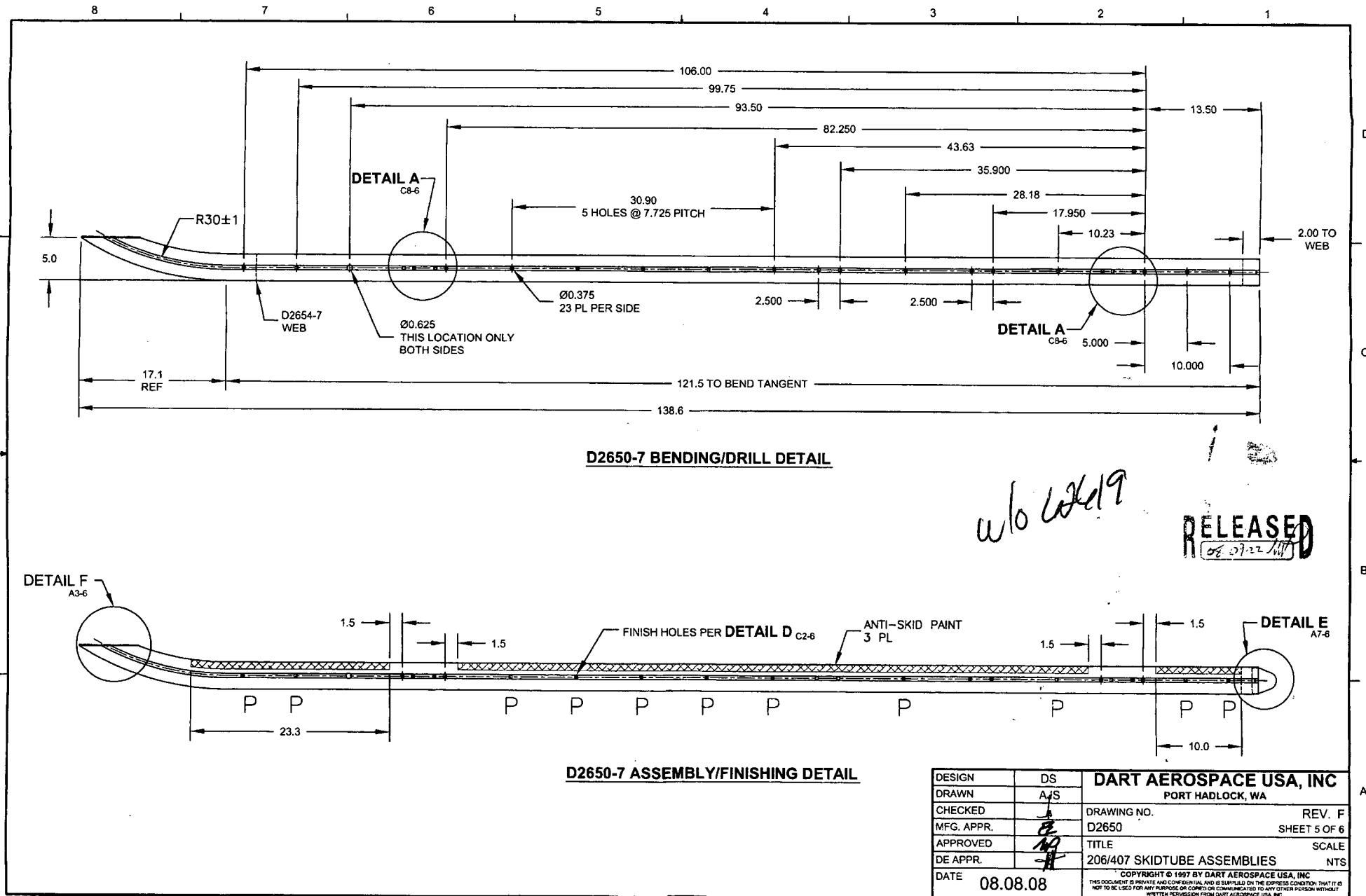
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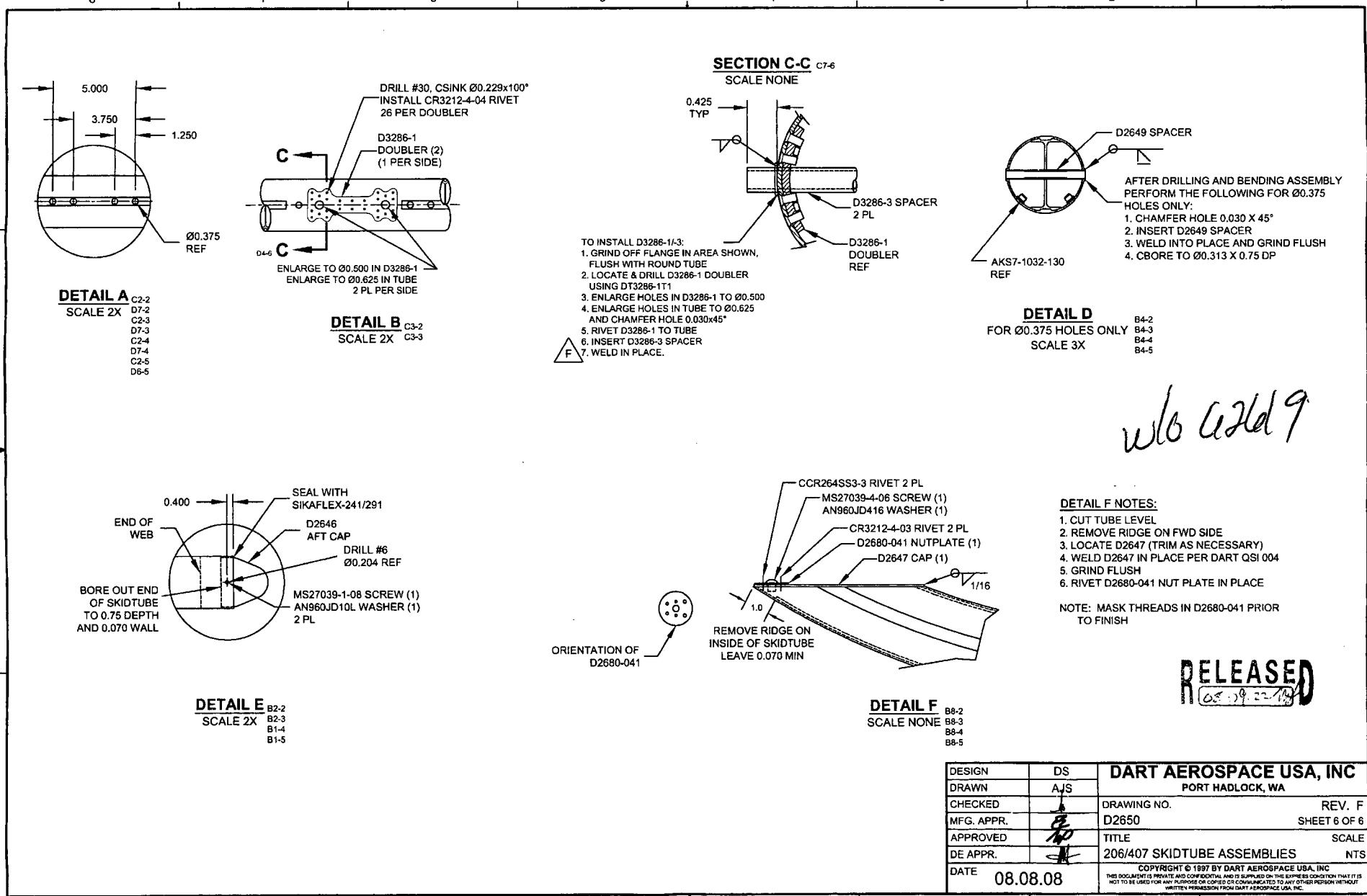
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NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622808
Part number: DA06 642 - 541
Description: 20# skid
Welding Process: Tig Mig
Base material: Aluminum
Current: AC DC

TEST REQUIREMENTS AND RESULTS

Visual: pass fail
Penetration: pass fail

UNACCEPTABLE

Cracks: pass fail
Undercut: pass fail
Pin holes: pass fail
Overlap (cold lap) pass fail
Porosity (surface): pass fail
Coloration: pass fail

Qualifier Barclay Elliott Date of Test Coupon 10-09-30

Welder Barclay Elliott Date of Test Coupon 10-09-30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.